

# Work Order ID 72883

Wednesday, August 17, 2011 2:42:14 PM

Page 1

Item ID: D2933-2

Accept

Revision ID:

Item Name: Saddle RH In. 206

Setup Start

Stop

Start Date: 8/17/2011 Start Qty: 8.00

Required Date: 8/25/2011 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 1 3-Machine Step No 2 of Folio and visually inspect as per

and 11/08/23  
B.A. 11/08/24

8 0

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

B.A. 11/08/24

8 0

120

0.00



QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

B.A. 11/08/24

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Stop



Start Date: 8/17/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

22 11-8-25

8

φ

8x φ m-11/08/25

140 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10:20

320°F

10:50

8x φ m-11/08/26

M 117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72883

Wednesday, August 17, 2011 2:42:14 PM



Page 3

Item ID: D2933-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH In, 206

Start Date: 8/17/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: ST428 0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

sf

(8x)

11-08-29

11/8/29

11.08.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 17, 2011 2:42:20 PM

Page 1

Work Order ID: 72883

Parent Item: D2933-2

Parent Item Name: Saddle RH In, 206



Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B100.06.2611New DWG rev (mpp 2069): EC1  
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	73.0000	1	8			

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	73	
64777	20	
66965	1	
69677	2	
70976	10	
✓ 72225	40	

8  
out 11/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 72883
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.107	0.114	0.110	0.113	Mic	118-20
B	0.100	0.140		.103	0.109	0.109	0.115	"	"
C	0.100	0.140		.120	0.122	0.120	0.120	"	"
D	0.210	0.230		.218	0.222	0.223	0.223	Vern	6A-01
E	1.245	1.255		1.250	1.250	1.250	1.250	"	"
F	1.245	1.255		1.250	1.250	1.250	1.250	"	"
G	2.495	2.505		2.500	2.500	2.500	2.500	"	"
H	0.510	0.515		0.512	0.512	0.512	0.512	"	"
I	1.572	1.582		1.578	1.578	1.578	1.578	"	"
J	2.495	2.505		2.500	2.500	2.500	2.500	"	"
K	0.257	0.262		.258	.258	0.258	0.258	"	"
L	0.312	0.317		.314	0.314	0.314	0.314	"	"
M	0.235	0.240		0.238	0.238	0.238	0.238	"	"
N	0.100	0.140		.111	.111	0.111	0.113	Mic	6A-03
O	0.540	0.560		.544	0.551	0.551	0.551	Vern	6A-01
P	0.490	0.510		.503	0.504	0.502	0.503	"	"
Q	3.715	3.725		3.720	3.720	3.720	3.720	"	"
R	2.470	2.510		2.490	2.490	2.490	2.490	"	"
S	0.240	0.270		.245	0.250	0.250	0.248	"	"
T	0.100	0.180		.135	0.135	0.135	0.135	"	"
U	1.625	1.635		1.630	1.630	1.630	1.630	"	"
V	1.362	1.372		1.368	1.368	1.368	1.368	"	"
W	0.316	0.321		.316	.316	0.316	0.316	"	"
X	1.125	1.145		1.138	1.138	1.138	1.137	test indicator	"
Y	1.565	1.585	DT8695 A/B	1.572	1.575	1.575	1.574	"	"
Z	0.178	0.198		.188	.188	0.188	0.188	R-6	ref.
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: <i>AK</i>
Date: 11/08/24

Audited by: <i>RF</i>
Date: 11.8.25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C	Page 1 of 1	

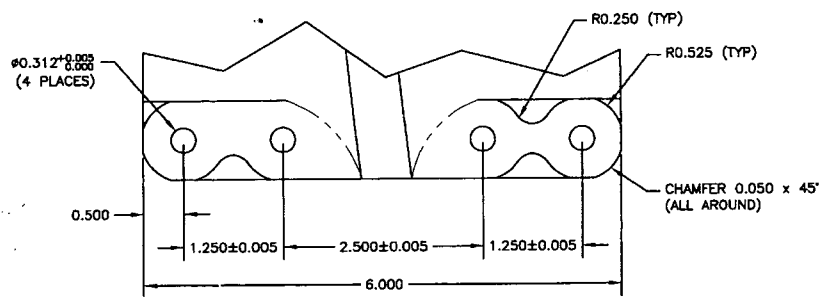
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		0.109	0.110	0.110	0.111	Mic	11B-120
B	0.100	0.140		0.109	0.108	0.110	0.110	"	"
C	0.100	0.140		0.121	0.122	0.122	0.121	"	"
D	0.210	0.230		0.223	0.223	0.222	0.222	Vern	GA-01
E	1.245	1.255		1.250	1.250	1.250	1.250	"	"
F	1.245	1.255		1.250	1.250	1.250	1.250	"	"
G	2.495	2.505		2.500	2.500	2.500	2.500	"	"
H	0.510	0.515		0.512	0.512	0.512	0.512	"	"
I	1.572	1.582		1.578	1.578	1.578	1.578	"	"
J	2.495	2.505		2.500	2.500	2.500	2.500	"	"
K	0.257	0.262		0.258	0.258	0.258	0.258	"	"
L	0.312	0.317		0.314	0.314	0.314	0.314	"	"
M	0.235	0.240		0.238	0.238	0.238	0.238	"	"
N	0.100	0.140		0.112	0.110	0.111	0.110	Mic	GA-03
O	0.540	0.560		0.551	0.552	0.552	0.552	Vern	GA-01
P	0.490	0.510		0.503	0.503	0.503	0.502	"	"
Q	3.715	3.725		3.720	3.720	3.720	3.720	"	"
R	2.470	2.510		2.490	2.490	2.490	2.490	"	"
S	0.240	0.270		0.247	0.249	0.249	0.249	"	"
T	0.100	0.180		0.135	0.135	0.135	0.135	"	"
U	1.625	1.635		1.630	1.630	1.630	1.630	"	"
V	1.362	1.372		1.368	1.368	1.368	1.368	"	"
W	0.316	0.321		0.316	0.316	0.316	0.316	"	"
X	1.125	1.145		1.139	1.138	1.137	1.136	Dial	HAPS-2
Y	1.565	1.585	DT8695 A/B	1.573	1.5725	1.574	1.575	"	"
Z	0.178	0.198		0.188	0.188	0.188	0.188	R-6	res.
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	KA
Date:	11/02/24

Audited by:	RF
Date:	11.8.25

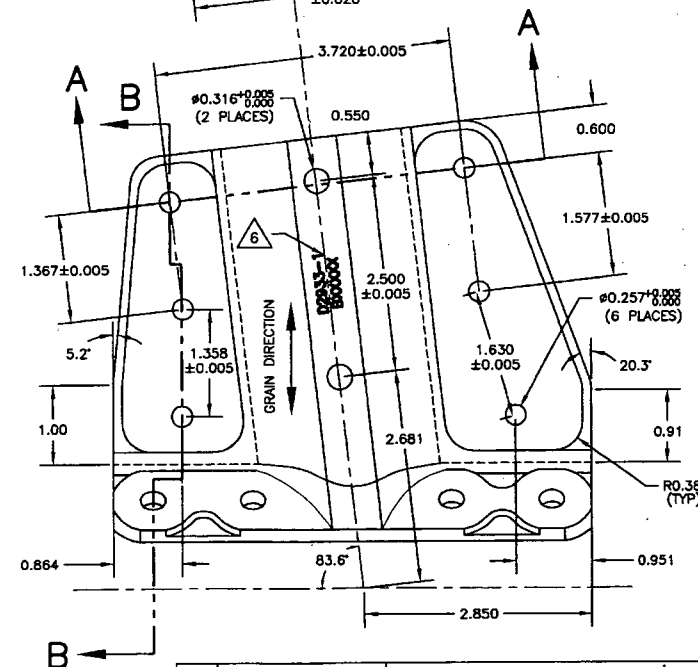
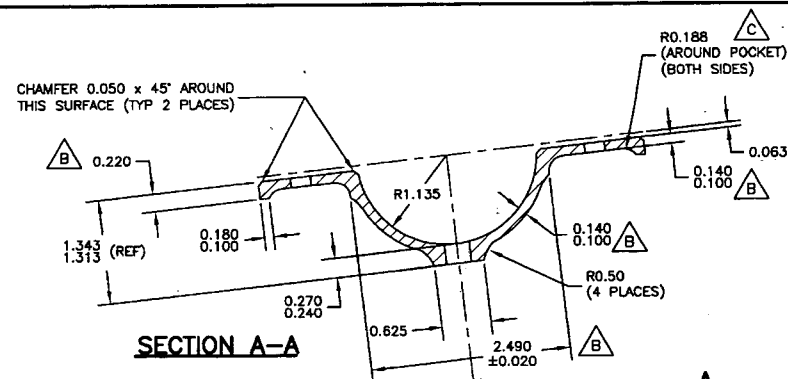
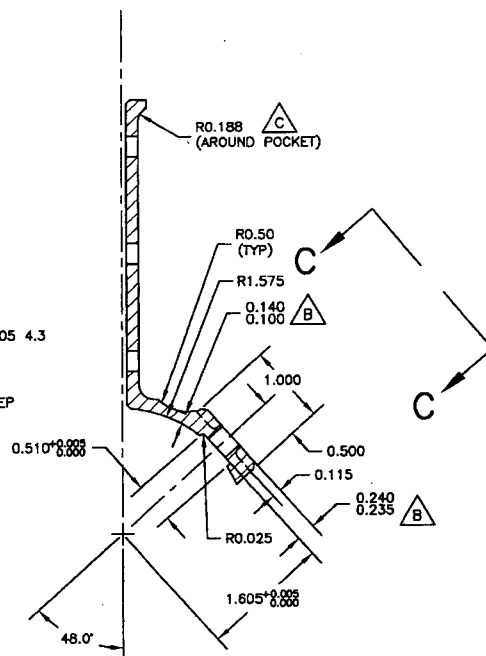
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07.02.12

